



Dart Aerospace Ltd.
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D3440-5
Job Sheet 173247



Part No: D3440-5 **Job Qty:** 4 ea
Part Name: Contoured Detent Clip Base (Supersedes B67-43001-217)



Part Weight: 0 lbs **Status:** Scheduled **Priority:** Medium
Job Created: 2/27/18 **Job Tracking No:**
Due Date: 4/9/18 **Created By:** Michelle Gagnon-Donovan
Type: SOLD **Description:**

Note: DWG REV B IPP A 05.06.30 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	4/7/18	4/7/18	0.00	0.00	Start Up Machining-2		mm 18/04/17
100	Bandsaw	4 pcs	4/7/18	4/7/18	0.00	2.32	Bandsaw1		"
110	CNC Vertical Machining	4 pcs	4/9/18	4/9/18	0.00	2.32	HAAS1-3		"
130	QC	4 pcs	4/9/18	4/9/18	0.00	0.00	QC8 Machining-2		18-04-18
140	Packaging	4 pcs	4/9/18	4/9/18	0.00	0.00	Packaging3-1		D.M.L 18-4-18
150	QC21-SA	4 Ea	4/9/18	4/9/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut blank: 1.250" x 1.250" x 2.000" long
Descriptions: 110 - Machine as per Folio FA536 and Dwg D3440Dwg Rev: ____ Identify as D3440-5Folio Rev: ____ Debur
130 - QC8- Inspect parts - second check
140 - Identify as per dwg & Stock Location: ____
150 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X01.250	6061-T6 Bar 1.25 X 1.25	.6840 ft (.171 ea)	90-Start up Operation	

F4137586 = 0.68

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.250X01.250	1	29	0

DART

AEROSPACE

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Container No: S061618

Part: D3440-5

Job No: 173247

Serial No/Batch: S061618

Revision:

Inspector:

Date: 04/17/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Contoured Detent Clip Base	0.750inches $\pm$ 0.030	0.780 0.720		
2	Contoured Detent Clip Base	0.200inches $\pm$ 0.010	0.210 0.190		
3	Contoured Detent Clip Base	0.630inches $\pm$ 0.030	0.660 0.600		
4	Contoured Detent Clip Base	1.800inches $\pm$ 0.030	1.830 1.770		
5	Contoured Detent Clip Base	0.130inches $\pm$ 0.030	0.160 0.100		
6	Contoured Detent Clip Base	0.900inches $\pm$ 0.030	0.930 0.870		
7	Contoured Detent Clip Base	0.380inches $\pm$ 0.030	0.410 0.350		

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